

§ 178.815

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paragraph (d)(1) of this section, there may be no leakage or permanent deformation that would make the IBC unsafe for transportation.

(2) For metal IBCs intended to contain liquids, when subjected to the 200 kPa (29 psig) and the 250 kPa (36 psig) test pressures specified in paragraphs (d)(2) and (d)(3) of this section, respectively, there may be no leakage.

(3) For rigid plastic IBC types 21H1, 21H2, 31H1, and 31H2, and composite IBC types 21HZ1, 21HZ2, 31HZ1, and 31HZ2, there may be no leakage and no permanent deformation which renders the IBC unsafe for transportation.

[Amdt. 178–103, 59 FR 38074, July 26, 1994, as amended at 66 FR 45185, 45386, Aug. 28, 2001]

§ 178.815 Stacking test.

(a) *General.* The stacking test must be conducted for the qualification of all IBC design types intended to be stacked.

(b) *Special preparation for the stacking test.* (1) All IBCs except flexible IBC design types must be loaded to their maximum permissible gross mass.

(2) The flexible IBC must be filled to not less than 95 percent of its capacity and to its maximum net mass, with the load being evenly distributed.

(c) *Test method.* (1) All IBCs must be placed on their base on level, hard ground and subjected to a uniformly distributed superimposed test load for a period of at least five minutes (see paragraph (d) of this section).

(2) Fiberboard, wooden, and composite IBCs with outer packagings constructed of other than plastic materials must be subjected to the test for 24 hours.

(3) Rigid plastic IBC types and composite IBC types with plastic outer packagings (11HH1, 11HH2, 21HH1, 21HH2, 31HH1 and 31HH2) which bear the stacking load must be subjected to the test for 28 days at 40 °C (104 °F).

(4) For all IBCs, the load must be applied by one of the following methods:

(i) One or more IBCs of the same type loaded to their maximum permissible gross mass and stacked on the test IBC;

(ii) The calculated superimposed test load weight loaded on either a flat plate or a reproduction of the base of

the IBC, which is stacked on the test IBC; or

(iii) The packaging may be tested using a dynamic compression testing machine. The test must be conducted at room temperature on an empty, unsealed packaging. The test sample must be centered on the bottom platen of the testing machine. The top platen must be lowered until it comes in contact with the test sample. Compression must be applied end to end. The speed of the compression tester must be one-half inch plus or minus one-fourth inch per minute. An initial preload of 50 pounds must be applied to ensure a definite contact between the test sample and the platens. The distance between the platens at this time must be recorded as zero deformation. The force “A” to then be applied must be calculated using the applicable formula:

Liquids: $A = (n - 1) [w + (s \times v \times 8.3 \times .98)] \times 1.5;$

or

Solids: $A = (n - 1) [w + (s \times v \times 8.3 \times .95)] \times 1.5$

Where:

A = applied load in pounds.

n = minimum number of containers that, when stacked, reach a height of 3 m.

s = specific gravity of lading.

w = maximum weight of one empty container in pounds.

v = actual capacity of container (rated capacity + outage) in gallons.

And:

8.3 corresponds to the weight in pounds of 1.0 gallon of water.

1.5 is a compensation factor that converts the static load of the stacking test into a load suitable for dynamic compression testing.

(d) *Calculation of superimposed test load.* For all IBCs, the load to be placed on the IBC must be 1.8 times the combined maximum permissible gross mass of the number of similar IBCs that may be stacked on top of the IBC during transportation.

(e) *Criteria for passing the test.* (1) For metal, rigid plastic, and composite IBCs there may be no permanent deformation which renders the IBC unsafe for transportation and no loss of contents.

(2) For fiberboard and wooden IBCs there may be no loss of contents and no permanent deformation which renders

the whole IBC, including the base pallet, unsafe for transportation.

(3) For flexible IBCs, there may be no deterioration which renders the IBC unsafe for transportation and no loss of contents.

[Amdt. 178-103, 59 FR 38074, July 26, 1994, as amended by Amdt. 178-119, 62 FR 24743, May 6, 1997; 65 FR 50462, 50463, Aug. 18, 2000; 66 FR 45386, Aug. 28, 2001]]

§ 178.816 Topple test.

(a) *General.* The topple test must be conducted for the qualification of all flexible IBC design types.

(b) *Special preparation for the topple test.* The flexible IBC must be filled to not less than 95 percent of its capacity and to its maximum net mass, with the load being evenly distributed.

(c) *Test method.* A flexible IBC must be toppled onto any part of its top upon a rigid, non-resilient, smooth, flat, and horizontal surface.

(d) *Topple height.* For all flexible IBCs, the topple height is specified as follows:

(1) Packing Group I: 1.8 m (5.9 feet).

(2) Packing Group II: 1.2 m (3.9 feet).

(3) Packing Group III: 0.8 m (2.6 feet).

(e) *Criteria for passing the test.* For all flexible IBCs, there may be no loss of contents. A slight discharge (e.g., from closures or stitch holes) upon impact is not considered to be a failure, provided no further leakage occurs.

[Amdt. 178-103, 59 FR 38074, July 26, 1994, as amended at 66 FR 45386, Aug. 28, 2001]

§ 178.817 Righting test.

(a) *General.* The righting test must be conducted for the qualification of all flexible IBCs designed to be lifted from the top or side.

(b) *Special preparation for the righting test.* The flexible IBC must be filled to not less than 95 percent of its capacity and to its maximum net mass, with the load being evenly distributed.

(c) *Test method.* The flexible IBC, lying on its side, must be lifted at a speed of at least 0.1 m/second (0.33 ft/s) to an upright position, clear of the floor, by one lifting device, or by two lifting devices when four are provided.

(d) *Criterion for passing the test.* For all flexible IBCs, there may be no damage to the IBC or its lifting devices

which renders the IBC unsafe for transportation or handling.

[Amdt. 178-103, 59 FR 38074, July 26, 1994, as amended at 66 FR 45386, Aug. 28, 2001]

§ 178.818 Tear test.

(a) *General.* The tear test must be conducted for the qualification of all flexible IBC design types.

(b) *Special preparation for the tear test.* The flexible IBC must be filled to not less than 95 percent of its capacity and to its maximum net mass, the load being evenly distributed.

(c) *Test method.* Once the IBC is placed on the ground, a 100-mm (4-inch) knife score, completely penetrating the wall of a wide face, is made at a 45° angle to the principal axis of the IBC, halfway between the bottom surface and the top level of the contents. The IBC must then be subjected to a uniformly distributed superimposed load equivalent to twice the maximum net mass. The load must be applied for at least five minutes. An IBC which is designed to be lifted from the top or the side must, after removal of the superimposed load, be lifted clear of the floor and maintained in that position for a period of five minutes.

(d) *Criterion for passing the test.* The IBC passes the tear test if the cut does not propagate more than 25 percent of its original length.

[Amdt. 178-103, 59 FR 38074, July 26, 1994, as amended at 66 FR 45386, Aug. 28, 2001]

§ 178.819 Vibration test.

(a) *General.* The vibration test must be conducted for the qualification of all rigid IBC design types. Flexible IBC design types must be capable of withstanding the vibration test.

(b) *Test method.* (1) A sample IBC, selected at random, must be filled and closed as for shipment.

(2) The sample IBC must be placed on a vibrating platform that has a vertical double-amplitude (peak-to-peak displacement) of one inch. The IBC must be constrained horizontally to prevent it from falling off the platform, but must be left free to move vertically and bounce.

(3) The test must be performed for one hour at a frequency that causes the package to be raised from the vibrating